

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002769**Date Inspected:** 29-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Jiang Jian Fei, Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Caltrans OBG, Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Ken Jobes, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, to randomly monitor welding and Quality Control (QC) functions. While on site, the QA Inspector observed and/or discovered the following:

New Tower Bay 1

The Caltrans QA Inspector randomly observed the machine Submerged Arc Welding (SAW) of fill passes on Weld No. SSD1-SA159 A/J-11A. The welding operator was Chen Hong Xia (I. D. No. 040460). The welding was in the flat groove (1G) position using Welding Procedure Specification (WPS) No. WPS-B-T-2221-B-U3c-S. Certified Welding Inspector (CWI), Liu Hua Jie (CWI No. 07120741) was present during this welding as was ABF QA Inspector, Xie Yan. The QA Inspector verified the electrode as JW-3 (EM12K) and the diameter of the electrode as 4.0 mm.

New Tower Bay 2

The Caltrans QA Inspector also randomly observed the machine Submerged Arc Welding (SAW) of fill passes on Weld No. ESD1-SA294 A/G-12A. The welding operator was Xue Yian (I. D. No. 040636). The welding was in the flat groove (1G) position using Welding Procedure Specification (WPS) No. WPS-B-T-2221-B-U3c-S. Certified Welding Inspector (CWI), Jiang Jian Fei (CWI No. 07120691) was present during this welding as was ABF QA Inspector, Yang Yi heng. The QA Inspector verified the qualifications of the welding operator, the electrode as JW-3 (EM12K) and the diameter of the electrode as 4.0 mm. The minimum preheat and maximum

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

interpass temperatures, voltage, amperage and travel speed were all verified as being within the parameters of the WPS.

All above observations appeared to meet the requirements of the job specifications.



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Jobes, Kenneth	Quality Assurance Inspector
Reviewed By:	Cochran, Jim	QA Reviewer
